

Work Order ID 58019

April 21, 2010 3:57:06 PM



Page 1

Item ID:	D4096-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Gasket					
Start Date:	21/04/2010	Start Qty:	1.00			
Required Date:	21/04/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4096	PA1 PA2	10-04-22							

100		0.00							
	FLOW WATER JET								

Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4096								
	Dwg Rev: PA1								
	Prog Rev:								
	2-Deburr if necessary								

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								

QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								

QC	Memo	0.00							
Quality Control									

→ inspection to PA2 Dwg only & 10/04/23 x4

QC APPROVAL

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

April 21, 2010 3:57:06 PM



Accept

**Setup Start**

Stop



Item Name: Gasket

Start Date: 21/04/2010 **Start Qty:** 1.00

**Cust Item ID:**

Required Date: 21/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Operation Description

Set Up/ Run Hours

Draw Number	Draw Rev.	Plan Code
----------------	--------------	--------------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

10/10/07 

MF
10-4-27

POSITIVE RECALL
EFFECTIVE 10/1/77 AUTH W
RELEASED 7 DATE 10.10.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 3:57:11 PM

Page 1

Work Order ID: 58019



Parent Item: D4096-1



Parent Item Name: Gasket

Start Date: 21/04/2010

Required Date: 21/04/2010

Comments: IPP Rev:A new issue DD 10.04.21 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	272.5000	2.2735			
NEOPRENE SHEET 0.063												

B10-4-22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT052

272.5

114176

272.5

114176

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 58019
Description: GASKET		Part Number: D4096-1
Inspection Dwg: D4096-1, Rev: PA2 PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒


First Article

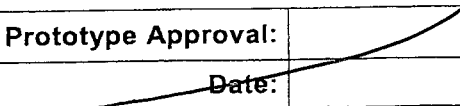
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Prototype

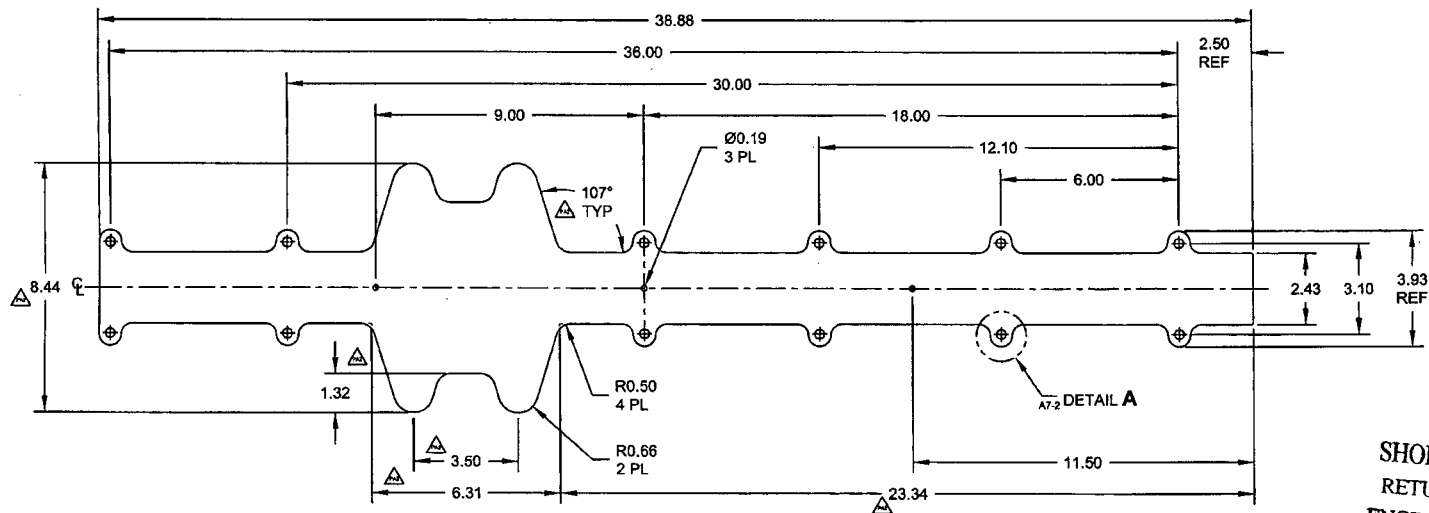
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .19	+ .005 - .001	.19	✓			
.300	± .030	.306	✓			
.300	± .030	.308	✓			
2.43	± .030	2.474	✓			
3.10	± .030	3.096	✓			
3.93	± .030	3.970	✓			
2.50	± .030	2.505	✓			
6.00	± .030	6.008	✓			
12.10	± .030	12.10	✓			
18.00	± .030	18.00	✓			
9.00	± .030	9.00	✓			
30.00	± .030	30.000	✓			
36.00	± .030	36.000	✓			
38.88	± .030	38.875	✓			
8.44	± .030	8.435	✓			
1.32	± .030	1.34	✓			
3.50	± .030	3.50	✓			
6.31	± .030	6.31	✓			
11.56	± .030	11.56	✓			
2.50	± .030					
.063	± .010	.063	✓			

Measured by: PB
Date: 10-4-23

Audited by: 
Date: 10/04/23

Prototype Approval: 
Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4096-1 GASKET 1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58019
10.04.22
PRELIMINARY ISSUE
10.04.22

NOTES:

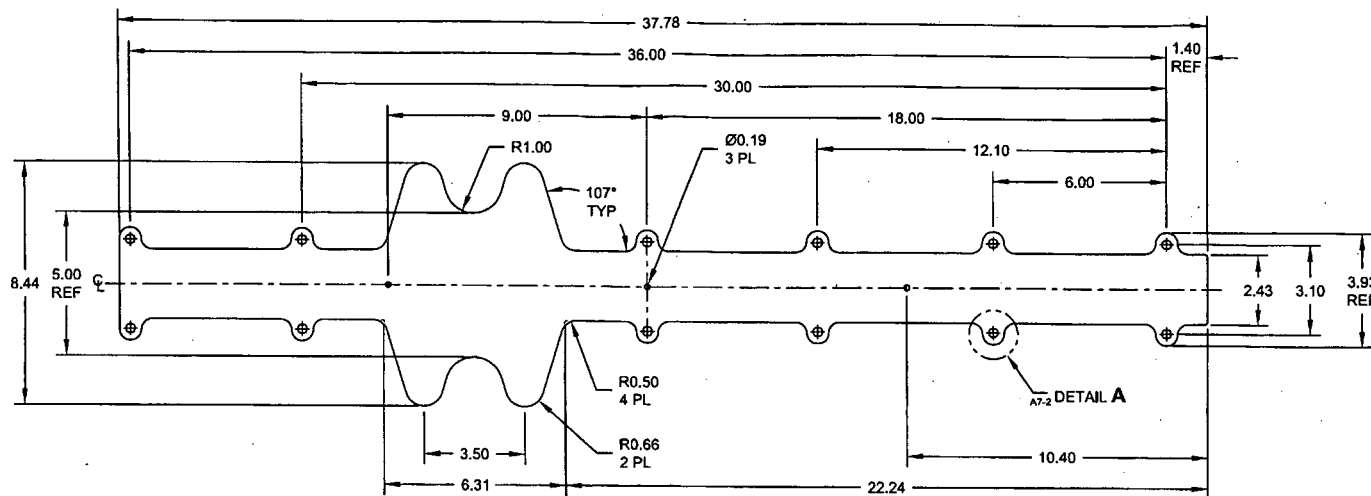
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REF DART MATERIAL SPEC M-NEO60-S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs EACH

PA2	ADDED CLEARANCE FOR INSIDE SADDLE INCREASED EDGE DISTANCE ON SAME PROFILE	MB	10.04.22
PA1	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. PA2
D4096 SHEET 1 OF 2
TITLE SCALE
GASKET NTS

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D4096-1 GASKET 1

58019
RELEASED
2010-09-07
ND

NOTES:

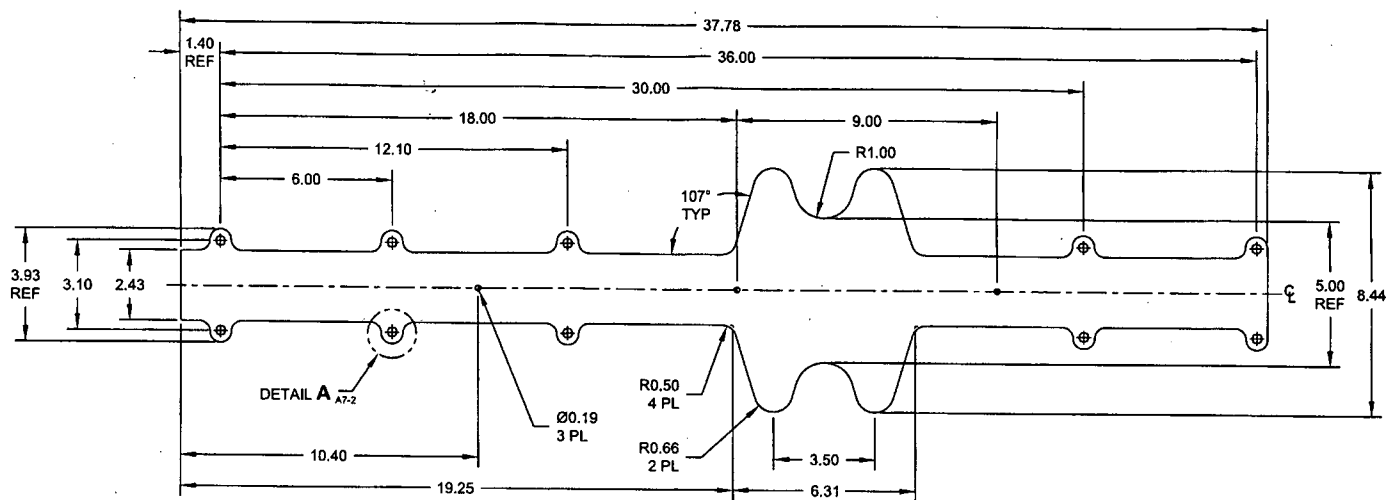
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REF DART MATERIAL SPEC M-NEO60-S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.41 lbs EACH
- 8) PARTS ARE SYMMETRIC ABOUT C

REV.	NEW ISSUE	DESCRIPTION	MB	10.04.20
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.04.20			

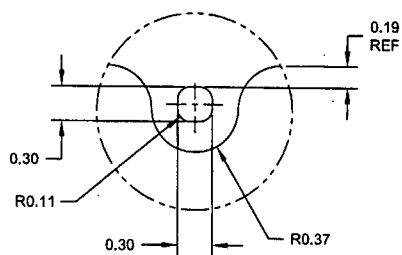
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D4096 SHEET 1 OF 2
TITLE SCALE
GASKET NTS

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D4096-3 GASKET 1



DETAIL A: TAB DETAIL

SCALE 4X
C3-1
C6-2

58019
RELEASED
2010-09-07
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4096	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GASKET	NTS
DATE	10.04.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Location/Lot Activity

October 7, 2010 1:33:22 PM

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Criteria : All Items All Locations Lot: 58019 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D4096-1 / Gasket	Main Warehouse ENG	58137	FAUT01		4.0000		4.0000		
					4/27/10	-2.0000	58019	-2.0000		-\$2.13
								-2.0000		-\$2.13
WIP Receipt	D4096-1 / Gasket	Main Warehouse ENG	58019	FAUT01		0.0000		0.0000		
					4/27/10	4.0000	58019	4.0000		\$4.25
								4.0000		\$4.25